

Work Order ID 70864

Thursday, June 16, 2011 11:55:31 AM

Page 1

Item ID: D3564-5

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 6/16/2011 Start Qty: 16.00

Required Date: 6/23/2011 Req'd Qty: 16.00

Reference:

Approvals:

Process Plan:

Date: 6/16/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-
Deburr if necessary

304. 063

131-6-16

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

131-6-16

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5 molo/20

Conto
x22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D3564-5

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/16/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

Deburr if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 ☐ Form Joggle as per Dwg D3564 on brake using Jig DT8157

SB 11/06/20

22

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Ensure joggle as per dwg D3429

SB 11/06/20

count

22

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:30

320 °F

4:00

22x 1/4" 11/06/21

M 11/5/28

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Page 3

Item ID: D3564-5

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Setup Start



Revision ID:

Stop



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Start Date: 6/16/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

22 ϕ BR 11-6-22

170

Identify as per dwg & Stock Location: FD-19 0.00

Packaging

Memo

0.00

Packaging

22 ϕ BR 11-6-22

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/22

MF
11-06-22

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Picklist Print

Thursday, June 16, 2011 11:55:38 AM

Page 1

Work Order ID: 70864



Parent Item: D3564-5



Parent Item Name: Wearshoe

Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev D added DT# 08.04.21 DD Verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	65.7000	1.5	25.26316			



304/316 Sheet .063



FB1-6-16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	65.7	
117275	2.3	
117653	63.4	

117653

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	70869
Description: Wearshoe		Part Number:	D3564-5
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	✓		T B01	
6.75	+/-0.030	6.75	✓		T	
10.00	+/-0.030	10.00	✓		T	
20.00	+/-0.030	20.00	✓		T	
30.00	+/-0.030	30.00	✓		T	
2.50	+/-0.030	2.50	✓		T	
3.227	+/-0.010	3.223	✓		V B02	
38.500	+/-0.010	38.500	✓		T	
5.500	+/-0.010	5.500	✓		T	
2.50	+/-0.030	2.50	✓		V	
2.432	+/-0.010	2.436	✓		V	
0.300 x 0.300	+/-0.010	301 x 303	✓		V	
Ø0.188	+0.005/-0.001	0.191	✓		V	
R0.375	+/-0.010	0.375	✓		R.G.	
0.063	+/-0.010	0.058	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-6-16	Date: 11/06/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DD

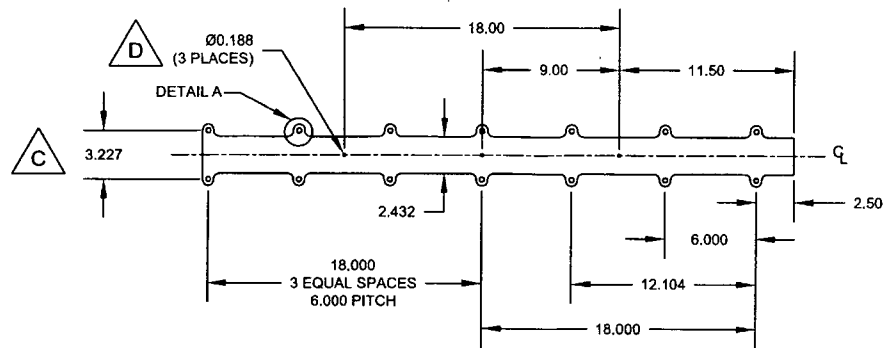
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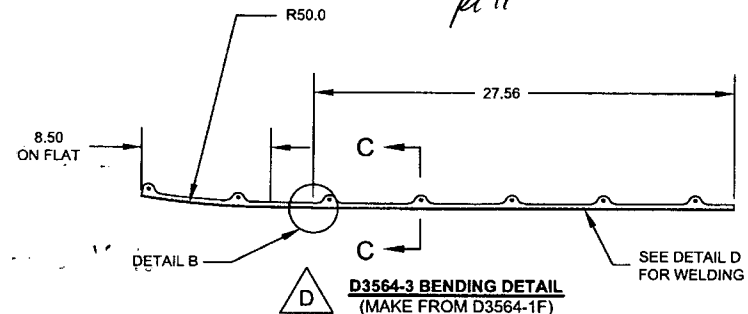
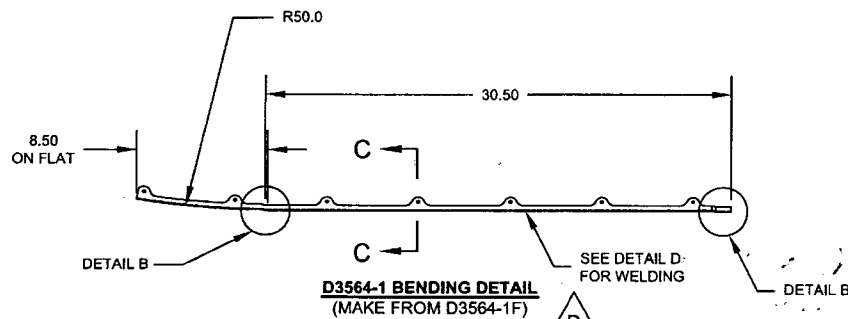


D3564-1F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70864

RELEASED
07.09.04

PH-06-14



D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3564 REV. D SHEET 1 OF 3 TITLE WEARSHOE SCALE 1:8 <small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

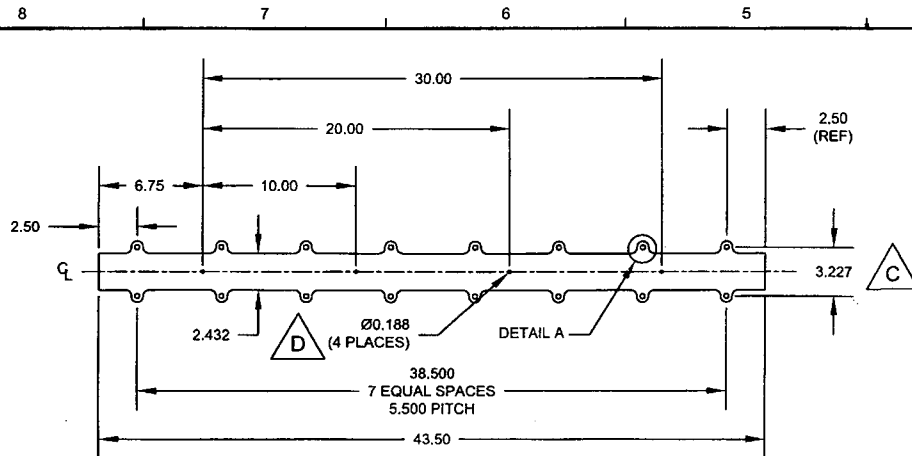
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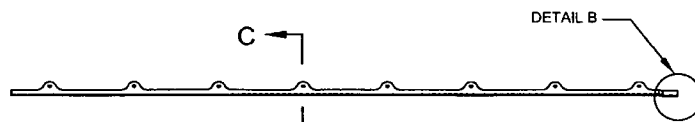
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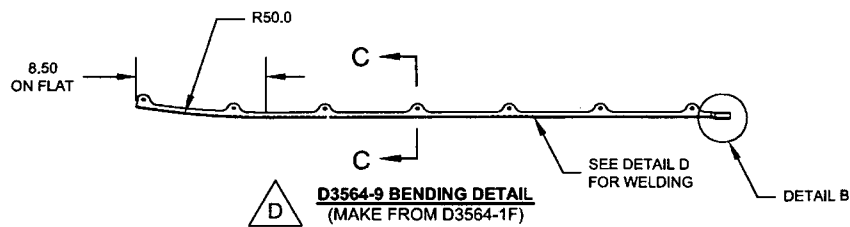
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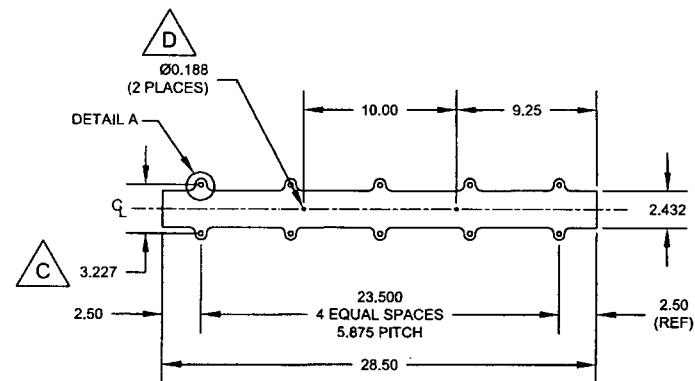
D3564-5F FLAT PATTERN



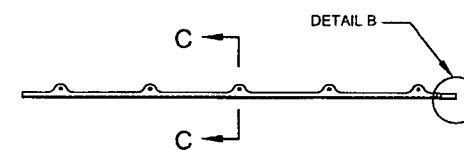
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



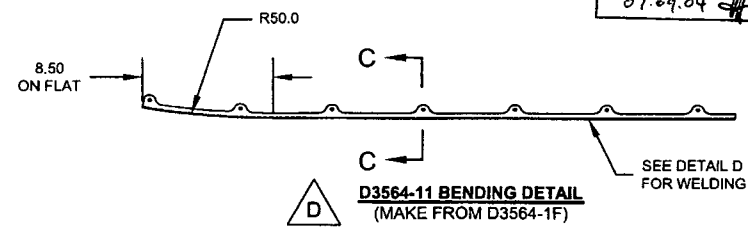
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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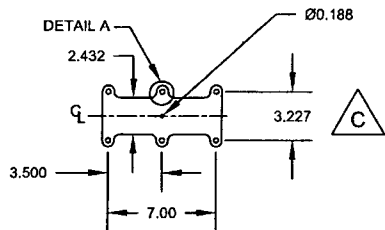
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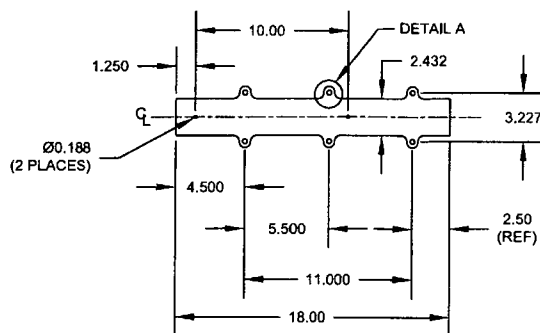
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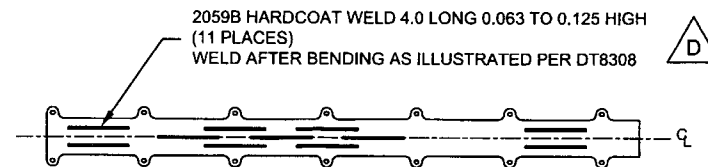
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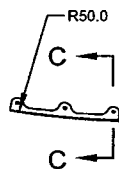
D3564-13F FLAT PATTERN



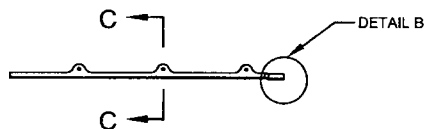
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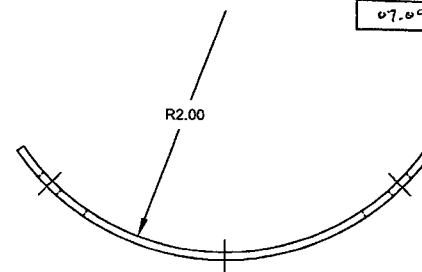
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



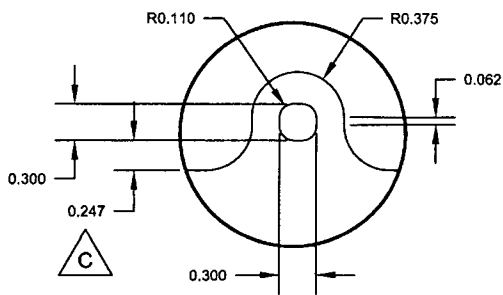
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



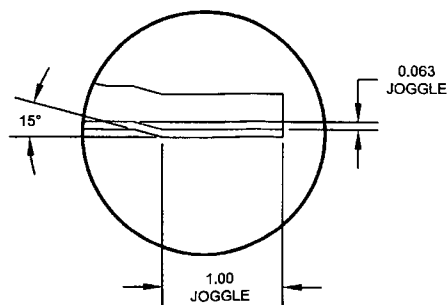
SECTION C-C
SCALE 1:1

RELEASED

07.09.04



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

u/o 70864

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CHECKED	PH	DRAWING NO. D3564	REV. D SHEET 3 OF 3
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8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

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